

ASAP

Work Order ID 135001

135001

Page 1

July 23, 2015 12:45:59 PM

Item ID: D4038-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Angle, Fwd, LH
 Start Date: 7/23/2015 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/7/2015 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: SA Date: 20150723 Pooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	E								

100 0.00
 100
 Bandsaw Memo 0.00 2 0 DAS 40
 Jeaspa Bandsaw Cut Blank 7.125" long 9-89 15/07/27

110 0.00
 110
 HAAS 1 Memo 0.00 2 0 DAS 40
 HAAS CNC vertical machine #1 Mill as per Dwg & Folio FA880 9-89 15/07/28
 Dwg Rev: E
 Folio Rev: AA
 Deburr DAS 20 15-08-04
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 135001

July 23, 2015 12:46:00 PM

135001

Page 3

Item ID: D4038-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle, Fwd, LH
 Start Date: 7/23/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/7/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									DAS 38
QC	Memo	0.00				②			9-89
Quality Control									AUG 05 2015
160	Identify as per dwg & Stock Location: <u>ST507</u>	0.00							
160									DAS 27
Packaging	Memo	0.00				②	JA		9-89
Packaging									AUG 05 2015
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							15/8/6
Quality Control									②

20150606

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

July 23, 2015 12:46:08 PM

Page 1

Work Order ID: 135001

135001

Parent Item: D4038-1

D4038-1

Parent Item Name: Angle, Fwd, LH

Start Date: 7/23/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased	No			100	f	48.0070	0.6	1.263158			

M6061T6A4 000W 250

6061T6 ANGLE 4.00 x 4.00 x .250

**

15/07/27

DAS

40

9-89

Location

Loc Qty

Loc Code

MAT028

48.007

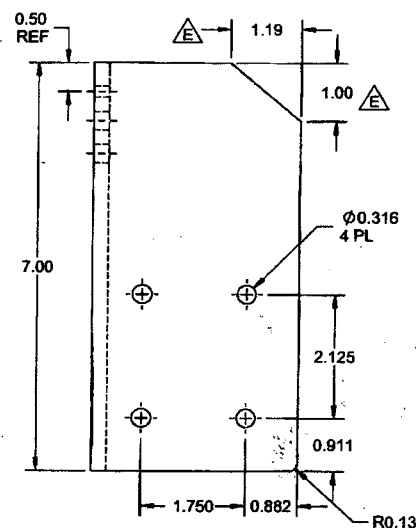
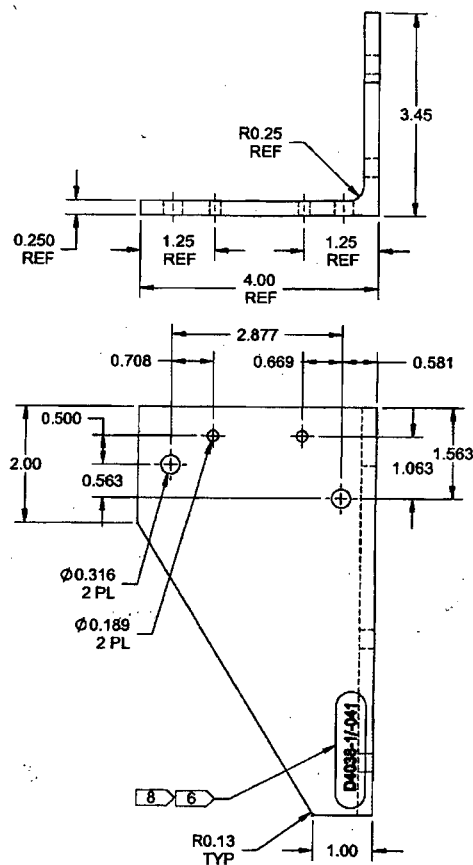
m118106

28.007

m128265

20

1.25



D4038-1 ANGLE, FWD, LH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (NEAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

RELEASED
R 2011-04-31

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 3 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	135001
Description: <u>Angle FWD LH</u>		Part Number:	D4038-1
Inspection Dwg: <u>D4038</u> Rev: <u>E</u>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	$\pm .030$	3.450	✓		VER	PHD-12
2.877	$\pm .010$	2.876	✓			
.769	$\pm .010$	.712	✓			
.669	$\pm .010$	.666	✓			
.581	$\pm .010$	.574	✓			
1.563	$\pm .010$	1.563	✓			
1.063	$\pm .010$	1.065	✓			
Ø.189	$\pm .005$	.191	✓			
Ø.316	$\pm .006$	.319	✓			
Ø.563	$\pm .010$	.563	✓			
.500	$\pm .010$	.498	✓			
7.00	$\pm .030$	7.00	✓			
1.19	$\pm .030$	1.19	✓			
1.00	$\pm .030$	1.00	✓			
Ø.316	$\pm .006$	.319	✓			
7.125	$\pm .010$	7.124	✓			
.911	$\pm .010$	.910	✓			
.882	$\pm .010$	.882	✓			
1.750	$\pm .010$	1.750	✓			
R.130	$\pm .030$	.125	✓		Rad G	

Measured by: <u>DAS 40</u>	Audited by: <u>JFC</u>	Preliminary Approval:
Date: <u>15/07/28</u>	Date: <u>2015-08-01</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15